

15/15

|                           |                     |       |
|---------------------------|---------------------|-------|
| <b>DART AEROSPACE LTD</b> | <b>Work Order :</b> | 22589 |
| <b>Description: Ring</b>  | <b>Part Number:</b> | D2655 |
| Drawing: D2655 Rev B      | <b>Qty:</b>         | 41    |

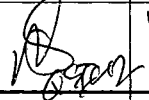

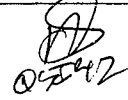
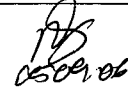
| Step | Location   | Procedure  | By  | Date     | Qty |
|------|------------|--|-----|----------|-----|
| 1    | EXPEDITING | Issue Work Order   | JA  | 05.03.02 | 20  |
| 2    | PURCHASING | Issue P/O: <u>2007072</u><br>Laser Cut per D2655<br>Material release note required                 | LC  | 05.03.02 | 40  |
| 3    | RECEIVING  | Check for transit damage and attach release note to W/O  | CL  | 05.03.02 | 41  |
| 4    | QC         | Inspect Level 6 and ensure release note is attached  | Z   | 05.04.02 | 41  |
| 5    | METAL      | <del>Tumble .030 Radius</del> <u>EB</u><br>Deburr any rough edges after tumbling                   | CPL | 05/04/02 | 41  |
| 6    | QC         | Inspect Level 7  | Z   | 05.04.02 | 41  |
| 7    | FINISHING  | Powder Coat per QSI 005 <u>4.3.5.1</u>   | MF  | 05/04/02 | 41  |
| 8    | QC         | Inspect Level 3  | CL  | 05/09/01 | 41  |
| 9    | STORES     | Identify and stock   | CL  | 05/09/01 | 41  |
| 10   | EXPEDITING | Close Work Order<br>Cost / Part: <u>11.59</u> <u>595</u> <u>05/09/06</u> <u>41</u><br><u>10.03</u> | D   | 05/09/02 | 41  |

| Rev. | Date     | Revision Notes:             | Revised By | Approved By |
|------|----------|-----------------------------|------------|-------------|
| A    | 97.08.27 | New                         | DH         |             |
| B    | 97.12.19 | Updated for Tumbling        | BW         |             |
| C    | 98.09.01 | Re-Format                   | KS         |             |
| D    | 00.06.22 | Removed P/O for powder coat | EC         |             |

RELEASED

EC 00.06.29

| W/O: |      | WORK ORDER CHANGES |  |    |      |     |                                 |                          |
|------|------|--------------------|--|----|------|-----|---------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   |  | By | Date | Qty | Approval<br>Mfg / Design<br>Mgr | Approval<br>QC Inspector |
|      |      |                    |  |    |      |     |                                 |                          |
|      |      |                    |  |    |      |     |                                 |                          |

| NCR:     |      | WORK ORDER NON-CONFORMANCE (NCR)  |   |                                  |                 |   |   |   |
|----------|------|---|---|----------------------------------|-----------------|---|---|---|
| DATE     | STEP | Description of NC<br>Section A  | Corrective Action   |                                  |                 | Verification<br>Section C   | Approval<br>Design Mgr  | Approval<br>QC Inspector  |
|          |      |   | Initial<br>Design Mgr   | Action Description<br>Design Mgr | Sign &<br>Date  |   |   |   |
| 05-04-20 | 5    | 16 need re-buffing due to laser cut marks (notches in material). Not noticed upon inspection how bad the marks would be show. |  | buff out marks                   | CFL<br>05/04/21 |  | <br>05/04/21 | <br>05/04/21 |
|          |      |   |   | re-powder coat<br>as per RS/004  |                 |   |   |   |
|          |      |   |   |                                  |                 |   |   |   |
|          |      |   |   |                                  |                 |   |   |   |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_

NOTE: Date &amp; initial all entries

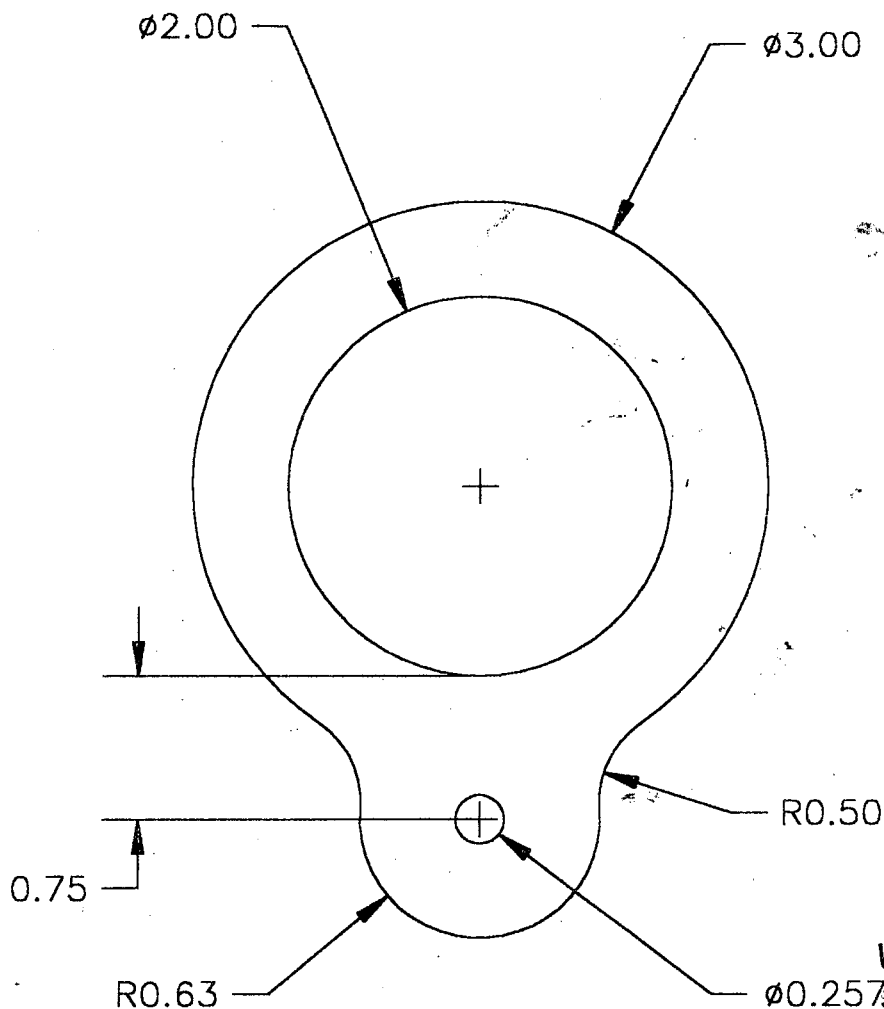
NCR: Yes ☒ No ☐ DQA:  Date: 05/09/06

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_



|                               |                                |   |                        |
|-------------------------------|--------------------------------|---|------------------------|
| DESIGN<br><i>[Signature]</i>  | DRAWN BY<br><i>[Signature]</i> | DART AEROSPACE USA, INC.<br>FAIRCHILD INTERNATIONAL AIRPORT, WA |                        |
| CHECKED<br><i>[Signature]</i> | APPROVED<br><i>[Signature]</i> | DRAWING NO.<br>D2655  | REV. B<br>SHEET 1 OF 1 |
| DATE<br>97:07:07              |                                | TITLE<br>RING   | SCALE<br>1:1           |
| A                             | 97:03:25                       | NEW ISSUE   |                        |
| B                             | 97:07:07                       | ADD ASTM A36 TO MAT. SPEC.                                      |                        |

RELEASED  
97/07/11 DS



UNLESS OTHERWISE NOTED  
WITHOUT NOTICE

WORK ORDER  
NO. 22589

NOTE: DEBURR ALL SHARP EDGES  
MATERIAL: AISI 1018/1020/1025 OR ASTM A36 0.250 THICK  
FINISH: POWDER COAT PER DART QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

# Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

Mar 01, 2005  
11:19 am

Work Order No : 0022589  
Project Name : D2655  
Project For : WK515  
Work Order Type : Main  
Main WO Number :  
House Part Number : D2655  
Description : Ring  
Manufactured : Yes  
Amount Req'd : 20  
Amount Done : 0  
Start Date : 03-01-05  
Est Finish Date : 03-30-05  
Act Finish Date :  
Drawings Req'd : No  
Ok for Approval :  
Approval Rec'd :

Department Code:  
Burden Flags : NNNNNNNN  
WO Status : Open  
Invoice State : Not Invoiced  
Invoice Date :  
Invoice Number :  
Invoice Amount : 0.00  
Order Entry No :  
OE Value : 0.00  
Est Margin : 0.000%  
Actual Margin : 0.000%  
\$0 Posted to Finished Goods

|                     | Estimated | Actual | Var. % | Posted | To Post |
|---------------------|-----------|--------|--------|--------|---------|
| =====               |           |        |        |        |         |
| Material Cost :     | 0.00      | 0.00   | 0.00   | 0.00   | 0.00    |
| Engineering Hours : | 0.00      | 0.00   | 0.00   |        |         |
| Engineering Cost :  | 0.00      | 0.00   | 0.00   | 0.00   | 0.00    |
| Production Hours :  | 0.00      | 0.00   | 0.00   |        |         |
| Production Cost :   | 0.00      | 0.00   | 0.00   | 0.00   | 0.00    |
| Packaging Hours :   | 0.00      | 0.00   | 0.00   |        |         |
| Packaging Cost :    | 0.00      | 0.00   | 0.00   | 0.00   | 0.00    |
| OverHead Hours :    | 0.00      | 0.00   | 0.00   |        |         |
| OverHead Cost :     | 0.00      | 0.00   | 0.00   | 0.00   | 0.00    |
| CNC Hours :         | 0.00      | 0.00   | 0.00   |        |         |
| CNC :               | 0.00      | 0.00   | 0.00   | 0.00   | 0.00    |
| Misc. Hours :       | 0.00      | 0.00   | 0.00   |        |         |
| Misc. :             | 0.00      | 0.00   | 0.00   | 0.00   | 0.00    |
| =====               |           |        |        |        |         |
| Burden :            | 0.00      | 0.00   | 0.00   |        |         |
| =====               |           |        |        |        |         |
| Total Cost :        | 0.00      | 0.00   | 0.00   |        |         |
| Margin :            | 0.000     | 0.000  |        |        |         |
| Selling Cost :      | 0.00      | 0.00   |        |        |         |

|                          | Estimated | Actual |
|--------------------------|-----------|--------|
| Labour Hrs/Amount Done : | 0.00      | 0.00   |
| Profits/(Loss) :         | 0.00      | 0.00   |



# Product Test Certificate

8250 130 St., Surrey, B.C., Canada V3W 8J9

Customer:  
WILKINSON  
A DIVISION OF PREMETALCO INC.  
888 S.E. MARINE DRIVE  
VANCOUVER  
BRITISH COLUMBIA V5X2V3

Customer Order No.: P10221MT001

Mill Order No.: 12-028022-01

Shipping Tally: 144-598

Grade Description: ASTM A36-97A

Ship Date: 15 Mar 01

Cert No.: 069024

Cert Date: 15 Mar 01

## Tensile Tests

| Heat Number | Product ID | Product Description   | YS (PSI)       | UTS (PSI)      | Elong % of 2IN 8IN | Bend Test | Average Hardness |
|-------------|------------|-----------------------|----------------|----------------|--------------------|-----------|------------------|
| 562768      | 562768C52  | 0.250 X 48.02 X 96.00 | 51000<br>44000 | 71000<br>62000 | 42<br>41           |           |                  |

## Heat Chemical Analysis, (%)

| Heat Number | C   | Mn  | S    | P    | Si  | Cu  | Ni  | Cr  | V    | Ch   | Mo   | Al   | Product of |
|-------------|-----|-----|------|------|-----|-----|-----|-----|------|------|------|------|------------|
| 562768      | .18 | .30 | .004 | .007 | .23 | .31 | .12 | .06 | .001 | .001 | .032 | .010 | Canada     |

FORM 037 REV 0

QUALITY ASSURANCE APPROVAL

CHECKED BY

\*\*\* TOTAL PAGE.01 \*\*\*

10619MD003-1 INDUSTRIAL LASE (P10221MT001.562768)

